




26

Work Order ID 70780

Wednesday, June 15, 2011 9:11:31 AM


Page 1

Item ID:	D3536-25	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Gasket					
Start Date:	6/15/2011	Start Qty:	16.00		Cust Item ID:	
Required Date:	6/22/2011	Req'd Qty:	16.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	6/16/15	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3536	Rev A


100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3536 <input type="checkbox"/> Dwg Rev: <u>A</u> <input type="checkbox"/> Prog Rev: <u>A</u> <input type="checkbox"/> 2-Debur if necessary								

B11-6-29

29

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

B11-6-29

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

Sub 6/29

counted
x26

Work Order ID 70780

Wednesday, June 15, 2011 9:11:31 AM

Page 2

Item ID: D3536-25

Accept

Revision ID:

Item Name: Gasket

Start Date: 6/15/2011 Start Qty: 16.00

Required Date: 6/22/2011 Req'd Qty: 16.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: FP

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CL 11/07/109

11/7/49

Picklist Print

Wednesday, June 15, 2011 9:11:37 AM

Page 1

Work Order ID: 70780

Parent Item: D3536-25

Parent Item Name: Gasket



Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063 		Purchased	No			100	sf	466.6800	0.5956	10.58844	16,		
NEOPRENE SHEET 0.063											B11-6-29		

Location

Loc Qty

Loc Code

MAT052

466.68

117295

66.68

118026

400

118026

26

DART AEROSPACE LTD		Work Order:	70780
Description: Gasket		Part Number:	D3536-25
Inspection Dwg: D3536 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
21.80	+/-0.030	21.80	✓		T BO1	
16.35	+/-0.030	16.35	>		T	
10.90	+/-0.030	10.90	>		T	
5.45	+/-0.030	5.45	x		T	
6.00	+/-0.030	6.00	x		T	
6.75	+/-0.030	6.75	x		T	
12.75	+/-0.030	12.75	x		T	
1.89	+/-0.030	1.885	x		V BO2	
0.30	+/-0.030	.304	?		V	
0.30	+/-0.030	.308	0		V	
Ø0.19	+0.005/-0.001	.19	0		V	

Measured by:	RB
Date:	11-6-29

Audited by:	S
Date:	11/6/29

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM	BE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

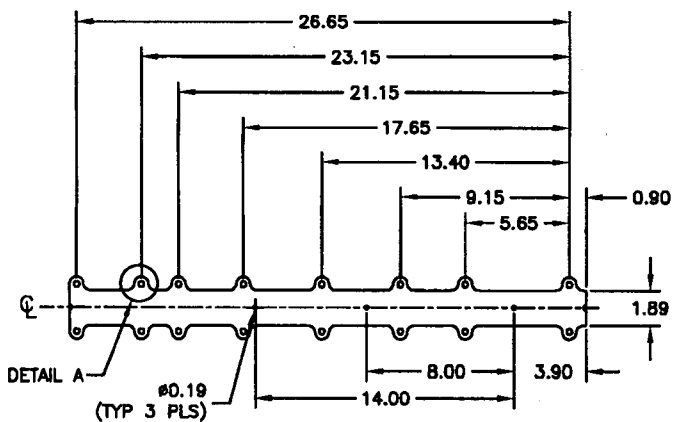
DART

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09-02-12-11

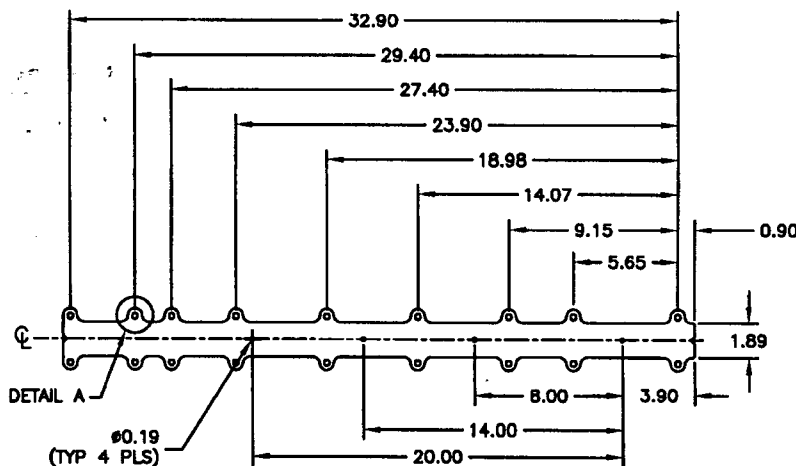
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 1 OF 6
		SCALE	1:10	
A	06.10.25	NEW ISSUE		

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70780

PH-06-15



D3536-11 GASKET



D3536-13 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.083)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT Q
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

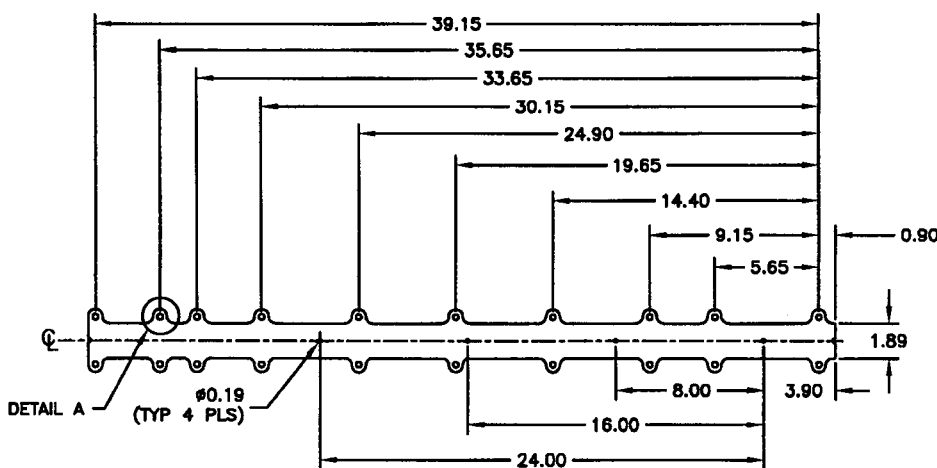
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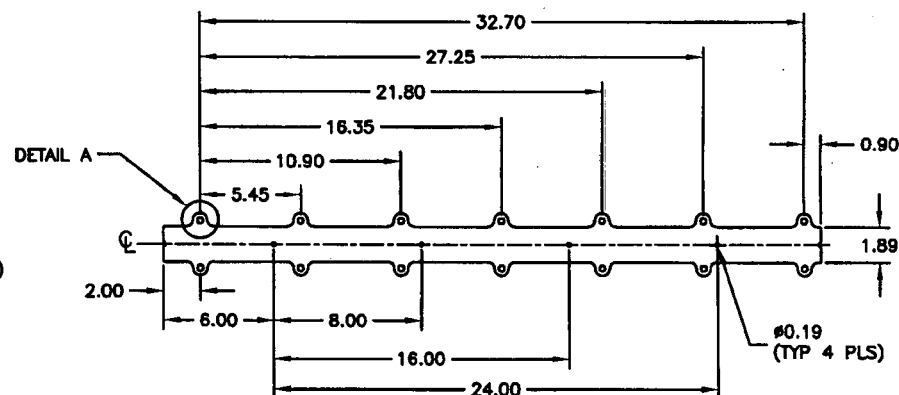
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 2 OF 6
		SCALE	1:10	

RELEASED
07.02.12

4070780



D3536-15 GASKET



D3536-21 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

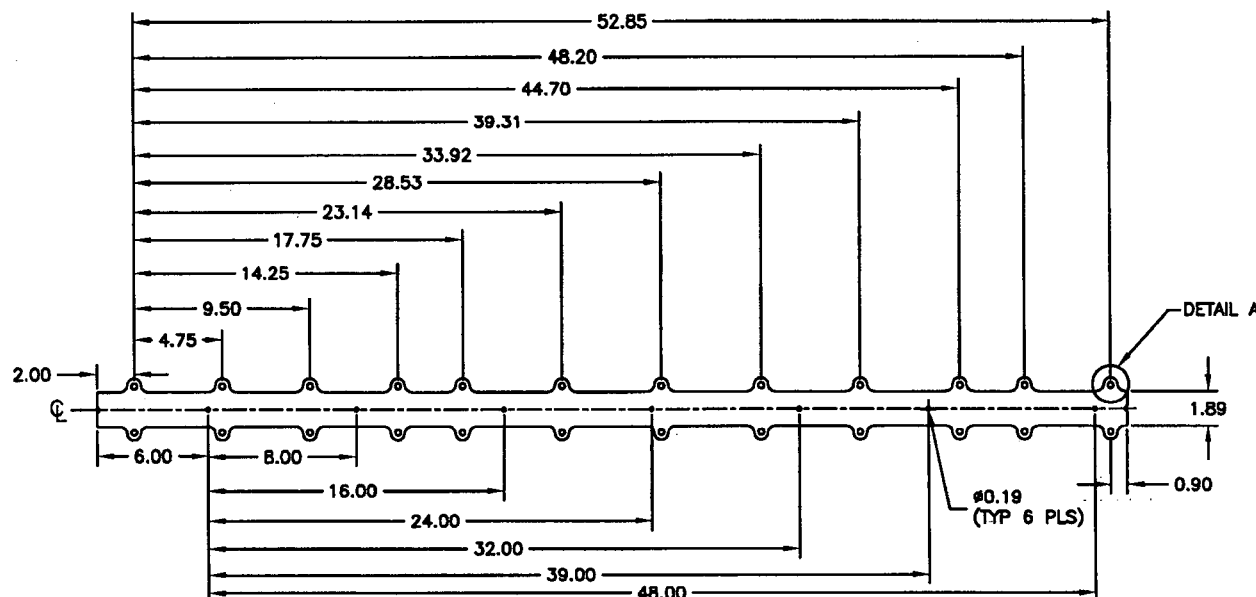
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

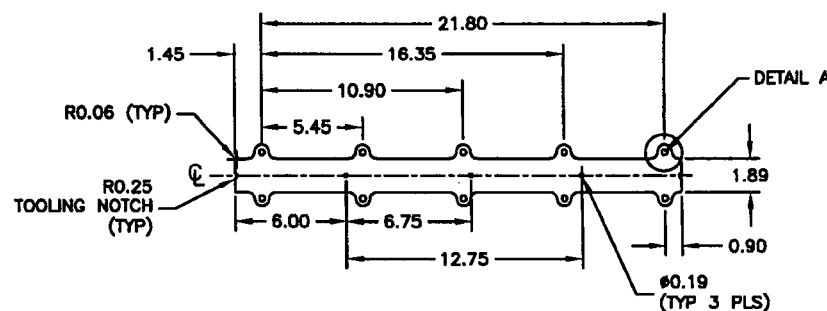
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 3 OF 6
				SCALE 1:10

RELEASED
070212



D3536-23 GASKET

W/0 70780



D3536-25 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

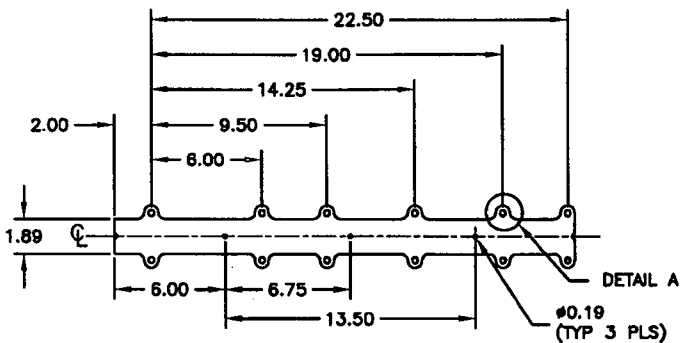
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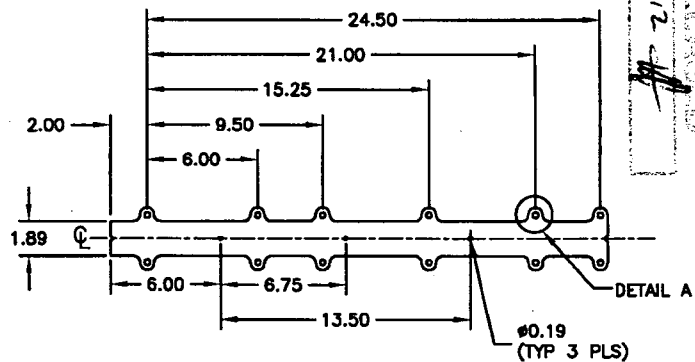
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	GASKET	REV. A
		DRAWING NO.	D3536	SHEET 4 OF 6
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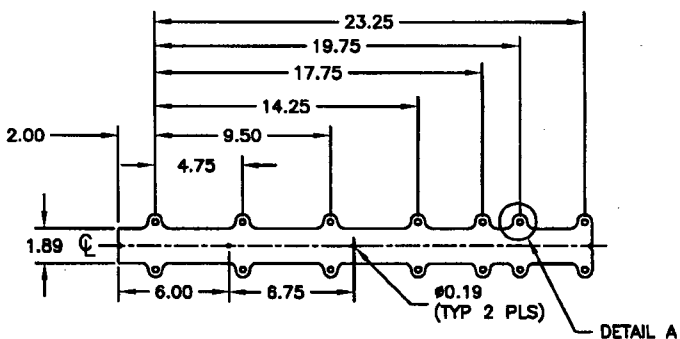


D3536-31 GASKET



D3536-33 GASKET

u/o 70780



D3536-35 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
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W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

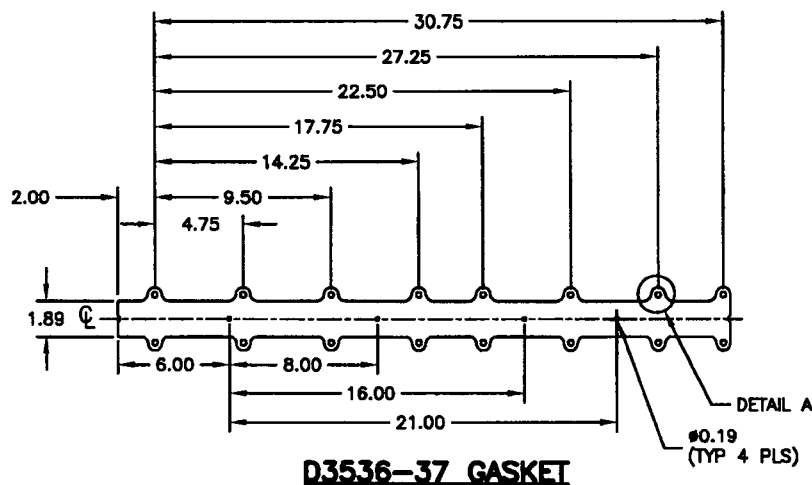
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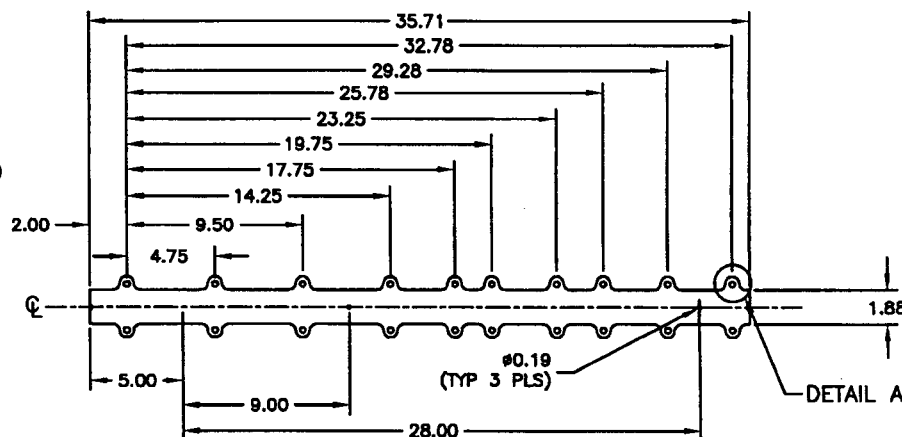
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DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 5 OF 6
		SCALE	1:10	

07.02.02

u6 70280



D3536-37 GASKET



D3538-39 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE080-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
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W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

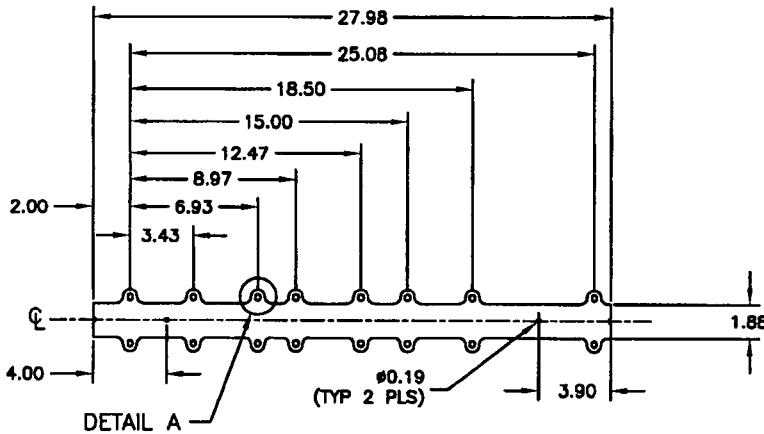
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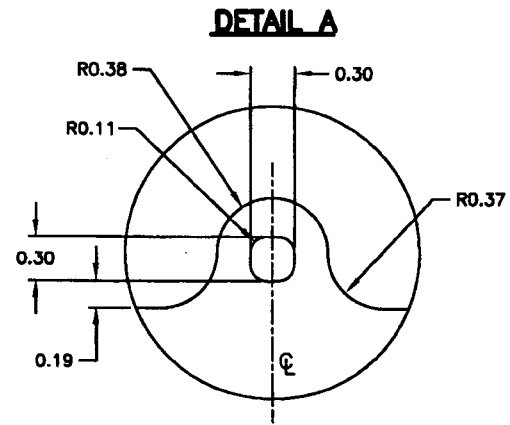
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CHECKED PH	APPROVED [Signature]	DRAWING NO. D3536	REV. A
DATE 06.10.25		TITLE GASKET	SHEET 6 OF 6
		SCALE 1:10	



D3536-41 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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